Work Order ID 69107

Monday, May 02, 2011 11:02:08 AM

Item ID: D350-748-101 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/16/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** NP **Date:** 11-05-11 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D350-748-141	F								
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-748-101 CHG002								
110	BENDING MACHINE - CROSSTUBES	0.00							
CNC Bend 1	**Memo**	0.00							
CNC Delta 100 Bender	Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT_____								
120	QC15- Crosstube Dimensional Check	0.00							
QC	**Memo**	0.00							
Quality Control									

SCRAP

NP 11-6-27 PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D350-748-101 **PAR #:** _____ **Fault Category:** X-tube Bending **NCR:** (Yes) No **DQA:** [illegible] **Date:** 11/07/15

11-710 **Resolution:** Scrap **Disposition:** Scrap **QA: N/C Closed:** [illegible] **Date:** 11-07-15

NCR: 69107

WORK ORDER NON-CONFORMANCE (NCR)

H.3338.06

DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
11-6-27	110	Tangent lines, Not as per Folio. Employee did Double check his own work. RC; Employee Error Training (under 3 months).	11.16.28 per QST	Tube is scrap.	JW 11-6-28	11-6-28 11.16.28	11.16.28	11/7/15

NOTE: Date & initial all entries

Work Order ID 69107

Monday, May 02, 2011 11:02:08 AM

Item ID: D350-748-101 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/16/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
HandFXtube	**Memo**	0.00							
Hand Finishing Crosstubes	***Stress relief*** Heat treat crosstube as per QSI010 4.3 Temp:_____ Start time:_____ Finish time:_____								
127	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

Work Order ID 69107

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00							
Crosstubes	**Memo**	0.00							
Crosstubes	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B &C Drill Jigs, Set-up drill table as per QSI 010 2-Deburr 3-Engrave Part # and Batch # as per Dwg D350-748-141 4-Remove all marks from tube within limits of D350-748-141 5- Apply a light coat of LPS3 on the interior of tube Batch:_____								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Cadplate per QSI017 4.1.9.1	0.00							
Outsource3	**Memo**	0.00							
Outsource process - Cad plate	Issue P/O: _____ Stress relief at 375° for 5 hours Magnetic Particle Inspect per ASTM E1444 Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375° for 8 hours, Chromate Treat Possibe Supplier: Southwest United Industries Ensure Certificate of Conformity is attached								
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 69107

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Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/16/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	SprayPaint	0.00							
SprayPaint	**Memo**	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Prime Outside of Tube as per Dart QSI 005 4.2								
190	QC14- Inspect Spray Paint	0.00							
QC	**Memo**	0.00							
Quality Control	Then,Wrap in plastic bag to protect from scratches								
200	Crosstubes	0.00							
Crosstubes	**Memo**	0.00							
Crosstubes	1-Install Ground wire Insert,then insert screw and washer 2-Install Abraision strips as per Dwg D350-748-141 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-141,Torque to 60-80 IN-LBS								

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID 69107

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Required Date: 5/16/2011 **Req'd Qty:** 1.00 **Customer:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
220	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									
230	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D350-748-101 Location:_____ PPP Rev:_____								
250	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Monday, May 02, 2011 11:02:14 AM

Work Order ID: 69107

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Required Date:** 5/16/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:A New Issue 06-07-05 JLM
IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
IPP Rev:C Rev B 07-11-15 DD
IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD
IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F
10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN		Manufactured	No			110	Each	1.0000	1	1			
Crosstube Turning Detail										SAO 11-06-27			
				Location			**Loc Qty**		**Loc Code**				
				LG046	68 & 15		1			(1)			
					64475		1						
ALS4-1032-225		Purchased	No			200	Each	1,069.000	1	1			
Insert													
				Location			**Loc Qty**		**Loc Code**				
				FP-B			28						
					110768		28						
				ST282			1041						
					110768		1041						
AN960JD10	NAS1149D0363J	Purchased	No			200	Each	0.0000	1	1			
Washer													

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Monday, May 02, 2011 11:02:14 AM

Work Order ID: 69107

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Required Date:** 5/16/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2856-400	Manufactured	No		200	f	215.2696	1.181	1.243158

Abraison Strip

Location		Loc Qty	Loc Code	
ST403		214.6		
	68076	214.6		
ST409		0.6696		
	63735	0.6696		

D3502-1	Manufactured	No		200	Each	31.0000	2	2

Support

Location		Loc Qty	Loc Code	
ST063		31		
	61206	12		
	61843	9		
	64004	10		

MS21920-20	Purchased	No		200	Each	72.0000	2	2

Clamp (per MIL-DTL-8783C)

Location		Loc Qty	Loc Code	
LG050		72		
	116799	22		
	117279	50		

MS27039-1-10	Purchased	No		200	Each	217.0000	1	1

Screw

Location		Loc Qty	Loc Code	
ST290		150		
	117441	150		
ST291		67		
	115935	67		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Monday, May 02, 2011 11:02:15 AM

Work Order ID: 69107

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Required Date:** 5/16/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN4-41A	Purchased	No		220	Each	198.0000	8	8
Bolt								

Location	Loc Qty	Loc Code
ST360	198	
115108	98	
115705	50	
116191	50	

AN4-6A	Purchased	No		220	Each	1,162.000	16	16
Bolt								

Location	Loc Qty	Loc Code
ST356	962	
115936	159	
116191	3	
116400	400	
116924	400	
ST358	200	
117514	200	

AN5-32A	Purchased	No		220	Each	159.0000	4	4
Bolt								

Location	Loc Qty	Loc Code
ST340	159	
115589	59	
117161	50	
117514	50	

AN960JD416 NAS1149D0463J	Purchased	No		220	Each	0.0000	32	32
Washer								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID: 69107

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Required Date:** 5/16/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN960JD516 NAS1149D0563J	Purchased	No		220	Each	0.0000	8	8	
Washer									
D3500-1	Manufactured	No		220	Each	44.0000	4	4	
Saddle									

Location	Loc Qty	Loc Code	
ST424	9		
66127	9		
ST424/25	20		
62207	20		
ST425	15		
61838	15		

D3501-1	Manufactured	No		220	Each	67.0000	16	16
Bushing								

Location	Loc Qty	Loc Code	
ST063	67		
61984	67		

MS21042L4	Purchased	No		220	Each	4,748.000	24	24
Nut								

Location	Loc Qty	Loc Code	
ST300	4748		
116823	1748		
117441	3000		

Dart Aerospace Ltd

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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 5/2/2011 **Required Date:** 5/16/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21042L5	Purchased	No	220	Each	1,171.000	4	4

Nut

Location	Loc Qty	Loc Code	
ST300	1171		
116105	411		
116548	260		
117441	500		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

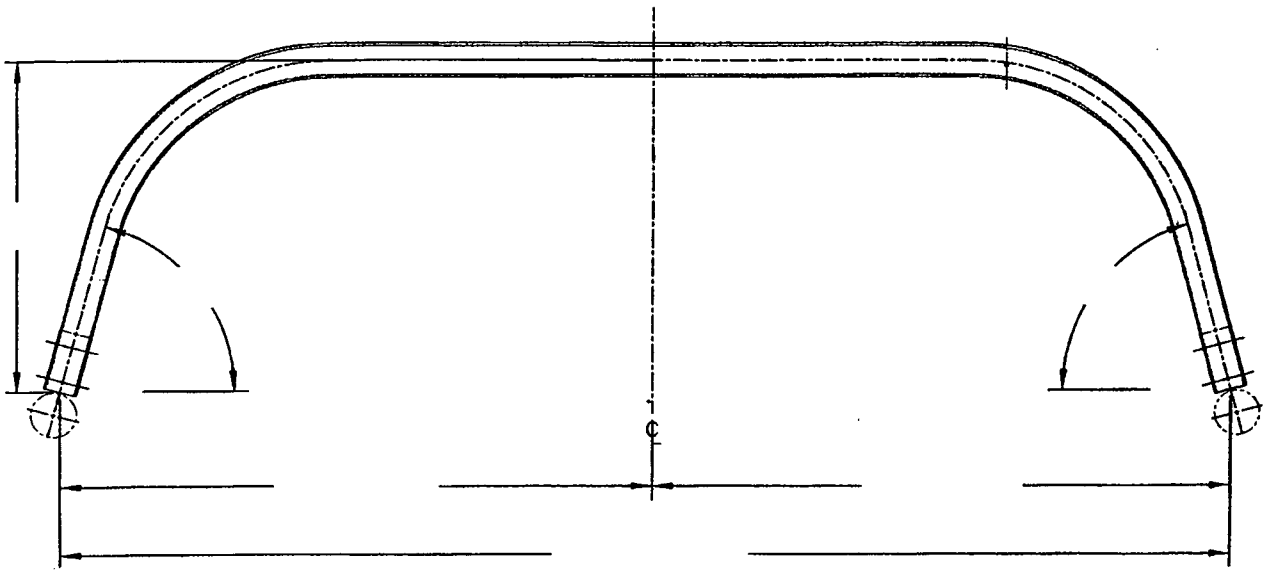
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69807
Description: Crosstube High Fwd (AS350/355)	Part Number:	D350-748-101
Inspection Dwg: D350-748-141 **Rev:** E		Page 1 of 1

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	10.08.23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69107

RELEASED
2011-01-18

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
 FINISHED LENGTH = 110.270±0.06
2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
 CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
 PER DART QSI 044 6.4 (VIBRATING STYLUS)
7) WEIGHT: 30.45 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
 NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

REV.	DESCRIPTION	BY	DATE
F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31

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MFG. APPR.		D350-748-141	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23		

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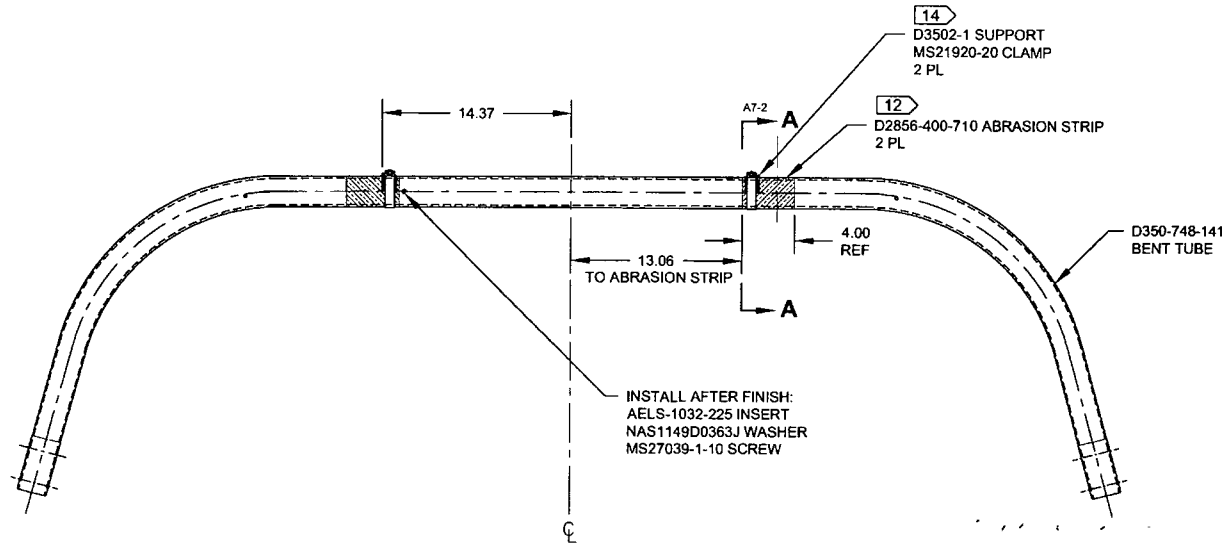
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

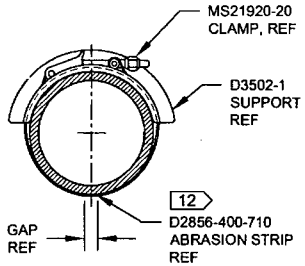
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D350-748-141
ASSEMBLY DETAIL

w/ sc9107



SECTION A-A D4-2
SCALE 4X

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2011 -01- 18

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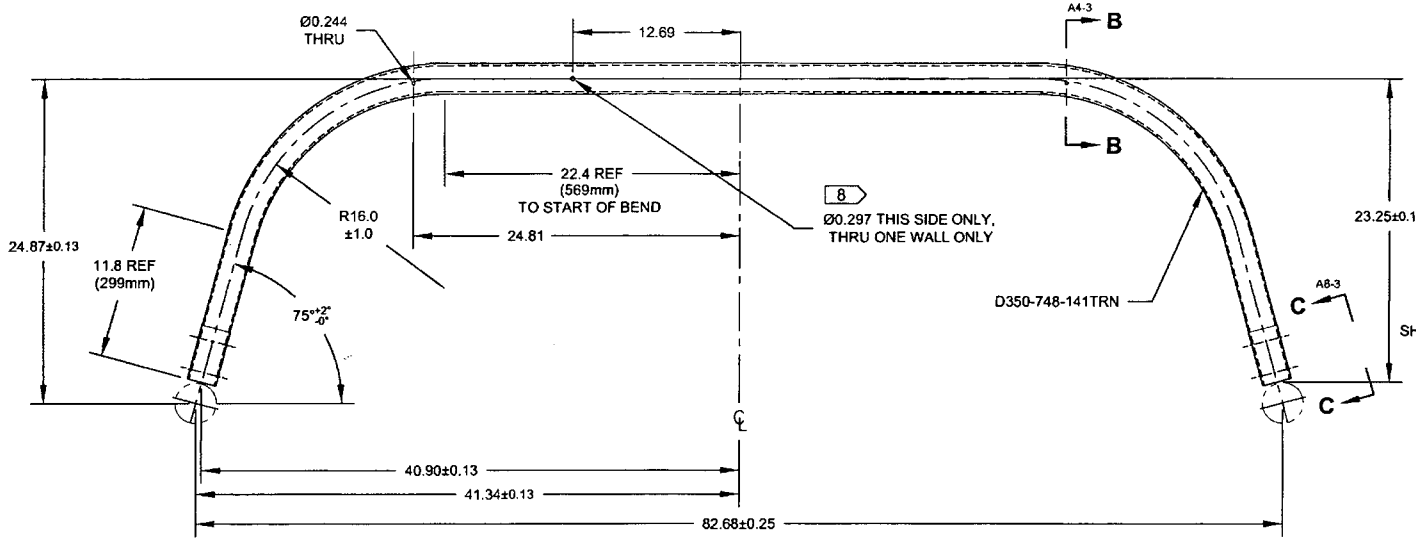
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

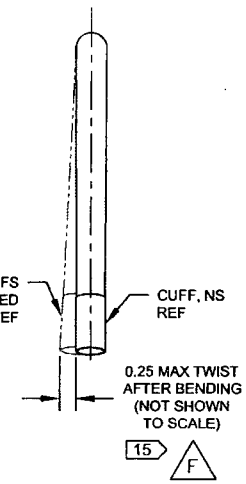
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

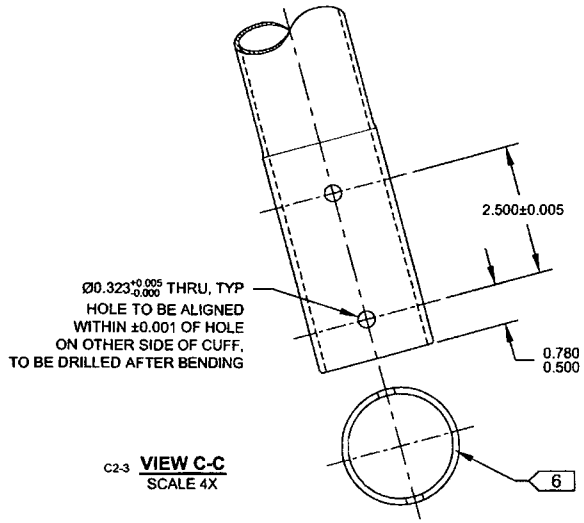
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

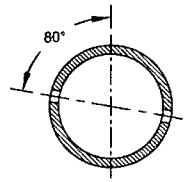




D350-748-141
BENDING AND DRILLING DETAIL 10



C2-3 **VIEW C-C**
SCALE 4X



SECTION B-B D3-3
SCALE 4X

u/0c9107

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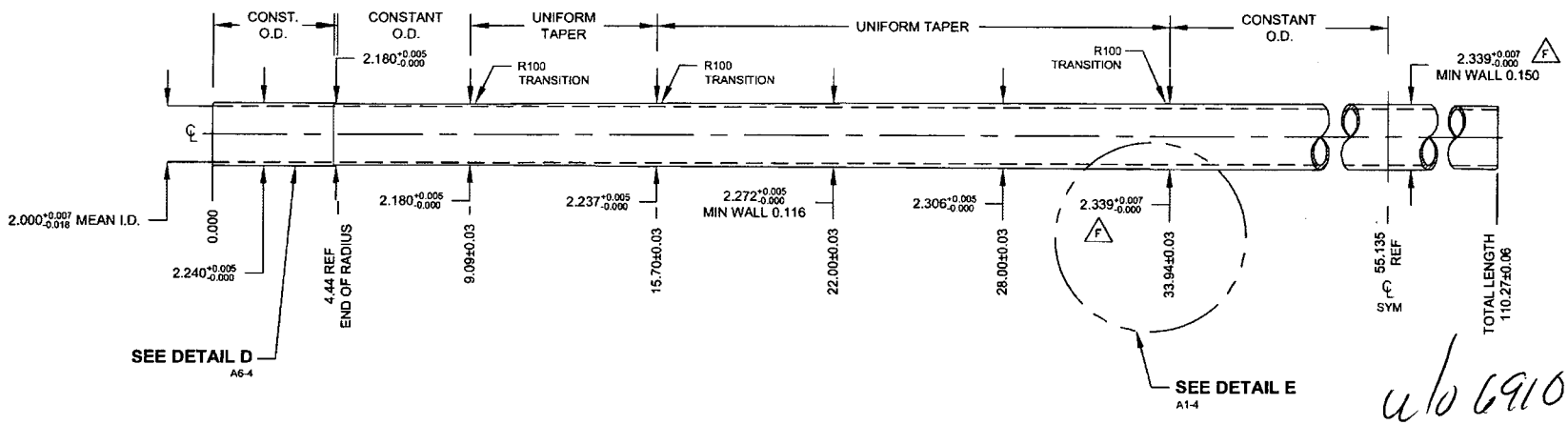
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

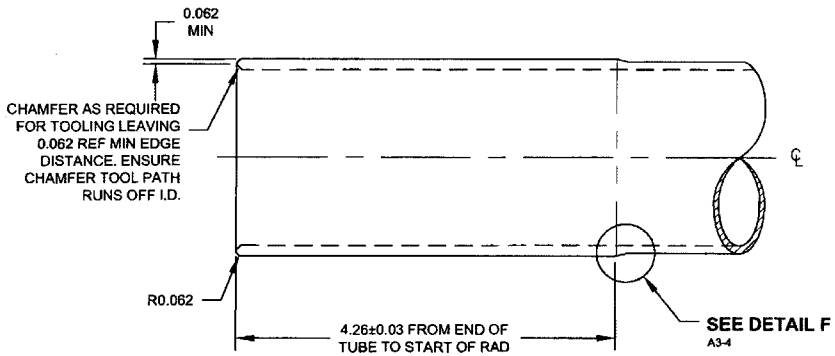
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NOTE: Date & initial all entries

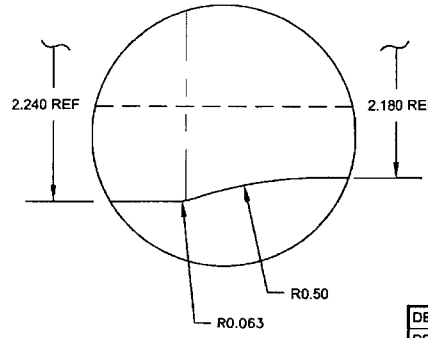


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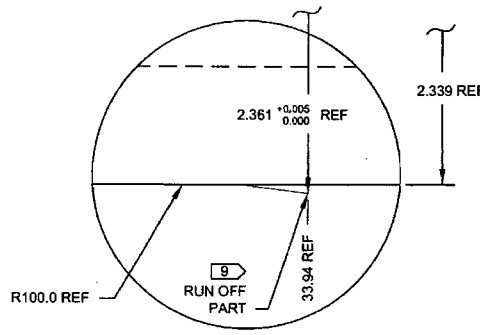
D350-748-141TRN TURNING DETAIL



DETAIL D: CROSSTUBE CUFF C7-4
SCALE 3X



DETAIL F: CUFF TRANSITION A5-4
NOT TO SCALE



RELEASED 2011-01-18

DETAIL E: TAPER RUN-OFF C3-4
NOT TO SCALE

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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